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(54) **A container, in particular for drugs, and a method for manufacturing the same.**

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Description

The present invention concerns a container, or packing, in particular for drugs, cosmetics and the like, and more in general for all those products which require an accompanying leaflet.

As it is known, all pharmaceutical products require an illustrative leaflet in which a series of information and warnings are reported which comprise composition of the drug, dosage and administration, contraindications and the like.

Said information require a certain minimum room to be printed in a readable way and therefore, considering the reduced size of said containers and similar packings, said information must be printed on a separate sheet, known as "internal leaflet".

It is evident that this affects the packing cost particularly in that each leaflet must be handled separately and then introduced into the formed box during the packaging operation.

Of course similar problems arise also for other kinds of products which require the presence of an illustrative leaflet, such as for instance cosmetics, parapharmaceutical products and the like.

GB-A-2104048 discloses a carton container for food and similar products wherein a flap forming additional panel is provided with e.g. a promotional item. This panel overlies a wall forming panel of the carton and is temporarily secured thereto by means of a peelable adhesive in the form of two bands and can be removed from the carton without spoiling it. In many cases the above disclosed embodiment cannot be used satisfactorily, in that the flap can be opened and closed again many times without any warning of the container having been opened. This is the case of medicinal products and of boxes that should not be opened until after it has been purchased, as e.g. when the purchase of the container may result in winning a prize, depending of what is printed on or under the flap.

There is therefore the need of providing a container, case or similar packing capable of solving the aforementioned problems, avoiding separate handling of internal leaflets and providing proof of the container opening.

Accordingly, an object of the present invention is to provide a container, case or similar packing including said leaflet in one piece.

A further object of the present invention is to provide a method for manufacturing said containers.

Said objects are achieved by the present invention, which relates to a container comprising the internal leaflet, and a method for the manufacture thereof.

More particularly, the present invention concerns a container, specially for packages of medi-

nal products and the like, of the type consisting of a single die-cut piece, folded and stuck, characterized according to claim 1.

Furthermore the invention concerns a method for manufacturing a container of the aforementioned type, characterized according to claim 9.

The invention will be now further described with reference to the accompanying drawings given by way of non limiting example and wherein:

- figure 1 is a top view of a die-cut piece of card board or the like according to the invention;
- figure 2 is a top view of the die-cut piece of fig. 1 partially folded; and
- figure 3 is a magnified perspective view of the partially formed container.

First of all, it is here pointed out that the word "die-cut piece" is meant to indicate not only all element obtained by die-cutting a cardboard sheet or suitable plastic material, but also a similar element obtained by other ways, such as for instance by molding without die-cutting.

Figures 1-3 show a preferential embodiment in which the die-cut piece 1 is drawn from the type of die-cut cardboard material generally used to obtain a container for packing for instance tablets in blister, and which comprises two longitudinal walls 3 and 4 and three transverse walls 2, 5, 6. The verso of wall 2 is stuck onto the recto of wall 6 to form the desired container or case. In all figures, the areas for adhesive application have been highlighted by hatching. The container closure is ensured in a known way by foldable tongues 7, 7', 8, 8'.

According to the invention, at least one of the sides of the "traditional" die-cut piece, namely at least one of the sides of walls 2-6, is provided with at least one flap adapted to be folded externally to the container itself and fixable in a detachable way to one of the container walls, so as to be able to substantially adhere to said wall and to be removed from it when desired. The terms "detachable fixing" and "detachable fixing means" as used herein mean a fixing mode and means of said foldable flap(s) to the corresponding container wall(s) in such a manner that not only a detachment is allowed, but in case further detachment and attachment operations can be carried out in succession of said flap(s) to said wall(s).

In the preferred embodiment of figures 1-3, the foldable flap is formed by three portions 9, 10 and 11, integral to each other and to the side 12 of wall 6, and provided with creasings allowing their easy folding.

In particular, portions 9 and 11 have a substantially equal area as that of walls 3 or 4, while portion 10 has an area corresponding to that of walls 5 or 6. In the formed or shaped container the recto of portions 9, 10 and 11 is placed in contact

with the verso of walls 3, 5 and 4, respectively, so that the portions are superimposed to the respective walls. It is obviously possible that the area of these portions is smaller than that of the corresponding walls so that the portions 9-11 overlap said walls only in part.

In order to maintain said portions adhering to the corresponding walls and in any case allow them to be unfolded when desired, means are provided for detachably bonding the same in correspondence with the edge 13 of portion 11.

Said means can be formed by any known device in the art, such as for instance strips of pressure adhesive of the repositionable type, for instance a non permanent adhesive of the type as used for self-adhesive repositionable tickets.

In the preferred embodiment of figures 1-3, said means comprise one or more sticking points permanently bonding the end edge 13 of portion 11 to the corresponding area 14 of wall 4. The area of portion 11 which is thus fixed to the underlying wall 4 is defined with reference to the remaining part of portion 11 by means of a pre-set breaking line 13 which allows, when broken, to unfold the portions 9-11. To make said breaking easier, the wall 4 is provided with a notch 16.

If an embodiment is wanted wherein it is possible to bond again the portion 11 to the wall 4 of the container after breaking along the line 15, the container bears detachable bonding means of the foldable flap to the container wall 4. The detachable bonding means can be for example in the form of pressure adhesive or, as shown in figs 1 and 3, in the form of a slot 16 cut in the wall 4 and in which a zone of the new edge of portion 11, as obtained after its detachment from the permanently stuck part to wall 4, is housed.

The recto of portions 9, 10 and 11 and the verso of wall 3 define an area large enough for printing information thereon and can therefore represent a valid alternative to the free internal leaflet.

According to a further embodiment, the foldable flap carries bonding means allowing its full detachment and withdrawal from the container body, said means (not shown) being advantageously formed by a pre-set breaking line. During the manufacturing operations of the aforescribed container, a die-cut piece 1 is obtained provided along its side with a foldable, 9-11, so as to be external and superimposed to at least part of one or more corresponding walls of the formed box, and said information is printed, before or after the die-cutting operation, on the area corresponding to the recto of flaps 9-11 and to the verso of wall 3 of the die-cut piece (when the container is formed, this area corresponds to the internal side of the flap and to the external side of the wall, in a way that

the information is not readable without breaking the flap 11 along its line 15).

The die-cut piece 1 is then fed to a folding and sizing machine, of a known type, with the foldable flap that in this case is positioned perpendicularly to the feeding direction.

Then the walls 2 and 3 are overlaid to the walls 5 and 4, driving the wall 2 adjacent to the wall 6. A bonding agent is then applied in correspondence with at least one of said walls and of the flap outer edge, i.e. of the edge 13 of the more external flap portion 11; a second folding is performed by superimposing the wall 3 to flap 9, sticking to one another the walls 2 and 6 and forming the container body. A third folding and sticking operation is carried out on the edge 13 onto the corresponding wall 4, resulting in a complete shaping of the container according to the invention, which is kept open and flat up to its final packaging by means of a retractor, according to the known technique. It is evident that the container according to the invention makes this operation much easier, avoiding a free internal leaflet handling.

Claims

1. A container, in particular for packages of drugs and similar products, of the type consisting of a single die-cut piece (1) folded and glued, and wherein at least one of the sides of said die-cut piece is provided with at least one flap (9, 10, 11) foldable externally to the container itself and with detachable bonding means (15, 6a) to keep said foldable flap or flaps (9, 10, 11) substantially adhering to one or more corresponding walls (3, 5, 4) of the formed container and allow their unfolding when desired, and wherein on at least part of said flap(s) (9, 10, 11) and/or said corresponding wall(s) (3, 5, 4), information, warnings or similar messages are printed, characterized in that said detachable bonding means comprise one or more bonding points (6a) positioned between the end edge (13) of said foldable flap (11) and the underlying container wall, to permanently bond said edge (13) to said wall (4), the bonded edge area being defined with respect to the remaining portion of said flap (11) by a pre-set breaking line (15) that enables to detach said remaining portion of said flap (11) from corresponding the container wall (4) and the end edge (13).
2. A container according to claim 1, further comprising means (15, 16) to fix in a reversible way said remaining portion of the flap (11) to the corresponding container wall (4).

3. A container according to claim 1 or 2, characterized in that said foldable flap is formed by three portions (9, 10, 11) integral to each other and to said side of the die-cut piece (1), said portions being superimposed to as many corresponding walls (3, 5, 4) of the container. 5
4. A container according to claim 2 or 3, characterized in that said reversible fixing means are in the form of one or more areas provided with re-positionable adhesive. 10
5. A container according to claim 2 or 3, characterized in that said reversible fixing means are in the form of at least a slot (16) provided in said wall (4), in correspondence with said breaking line (15) of said foldable flap (11). 15
6. A container according to one of claims 1 to 5, characterized in that said foldable flap (9, 10, 11) further comprises means for fully detaching the same from the container body. 20
7. A die-cut piece for forming a container according to one of claims 1 to 7, comprising at least one flap extending from the side of at least one of the container walls (4), said flap (9-11) being foldable on corresponding container walls (3, 5, 4) once the container is formed, characterized in that the end edge area of said foldable flap (11) is defined with respect to the remaining part of said flap (11) by means of a pre-set breaking line (15) to provide a receiving area for one or more bonding points to permanently bond said end edge area (13) to a corresponding container wall (4) once the container is formed. 25 30 35
8. A die-cut piece according to claim 7, wherein said breaking line (15) is provided with a protruding portion and a slot (16) is correspondingly located on the corresponding container wall (4). 40
9. A method for manufacturing a container according to one of claims 1 to 7, comprising the steps of: 45
 - obtaining a die-cut piece (1) provided, along at least one of its sides (12), with at least a foldable flap (9-11), in a way it results to be external and able to be superimposed to it least part of one or more corresponding walls (3, 5, 4) of the formed container; 50
 - printing, before or after the manufacture of said die-cut piece, a text and/or information required on said wall or walls (9, 10, 11) and/or on the internal side of said foldable flap(s) (3, 5, 4); 55

folding and sticking to each other the die-cut walls (2, 6) to form the container body; and folding said flap(s) (9-11) and fixing it (them) in a detachable way onto the corresponding wall(s) (3, 5, 4) of the container, characterized in that a pre-set breaking line (15) is die-cut at the end edge (13) of said foldable flap (11) to define said end edge area (13) from the remaining portion of said flap (11), and in that said end edge (13) is permanently bonded to the corresponding area (14) of the corresponding container wall (4) upon forming of the container.

10. A method according to claim 9, to manufacture a container according to claim 3, characterized by the further steps of:
 - feeding said die-cut pieces (1) to a folding and sizing machine with said foldable flap (9-11) perpendicular to the feeding direction;
 - performing a first folding by driving adjacent to one another the two container walls (2, 6) to be bonded;
 - applying a bonding agent in correspondence with at least one of said walls (2, 6) and the end edge area (13) of said flap (9-11);
 - performing a second folding by sticking to each other said walls (2, 6) and superimposing a first wall (3) of the container to the more internal part (9) of said foldable flap (9-11); and
 - performing a third folding by superimposing two subsequent walls of the container (5, 4) to the remaining two edges (10, 11) of said foldable flap (9-11) and fixing said end edge (13) of the foldable flap to the corresponding wall (4) of the box, provided with said slot (16).

Patentansprüche

1. Behälter, insbesondere für Verpackungen von Arzneimitteln und ähnlichen Produkten, des Typs, der aus einem einzigen gefalteten und verklebten Stanzstücks (1) besteht, und wobei mindestens eine der Seiten des Stanzstücks mit mindestens einer Klappe (9, 10, 11), die außen auf den Behälter selbst faltbar ist, und mit lösbaren Verbindungsmitteln (15, 6a), versehen ist, um die faltbare Klappe oder die faltbaren Klappen (9, 10, 11) an ein oder mehr entsprechenden Wänden (3, 5, 4) des gebildeten Behälters in wesentlichen haftend zu halten und um ihr Aufklappen zu gestatten, falls gewünscht, und wobei auf mindestens einen Teil der Klappe(n) (9, 10, 11) und/oder die entsprechende Wand (die entsprechenden Wände) (3, 5, 4) Informationen, Warnungen oder ähnliche Mitteilungen gedruckt sind, dadurch gekennzeichnet, daß die lösbaren Verbindungsmittel

- ein oder mehr Verbindungsstellen (6a) aufweisen, die zwischen dem Endrand (13) der faltbaren Klappe (11) und der darunterliegenden Behälterwand positioniert sind, um den Rand (13) mit der Wand (4) dauerhaft zu verbinden, wobei der verbundene Randbereich in bezug auf den übrigen Bereich der Klappe (11) von einer vorgegebenen Bruchlinie (15) definiert ist, die es ermöglicht, den übrigen Bereich der Klappe (11) von der entsprechenden Behälterwand (4) und dem Endrand (13) zu lösen.
2. Behälter nach Anspruch 1, der ferner Mittel (15, 16) aufweist, um den übrigen Bereich der Klappe (11) auf umkehrbare Weise an der entsprechenden Behälterwand (4) zu befestigen.
 3. Behälter nach Anspruch 1 oder 2, dadurch gekennzeichnet, daß die faltbare Klappe von drei Bereichen (9, 10, 11) gebildet ist, die miteinander und mit der Seite des Stanzstücks (1) integral sind, wobei diese Bereiche gleich vielen entsprechenden Wänden (3, 5, 4) des Behälters überlagert sind.
 4. Behälter nach Anspruch 2 oder 3, dadurch gekennzeichnet, daß die umkehrbaren Befestigungsmittel in Form von ein oder mehr Flächen sind, die mit repositionierbarem Klebstoff versehen sind.
 5. Behälter nach Anspruch 2 oder 3, dadurch gekennzeichnet, daß die umkehrbaren Befestigungsmittel in Form von mindestens einem in der Wand (4) vorgesehenen Schlitz (16) in Übereinstimmung mit der Bruchlinie (15) der faltbaren Klappe (11) sind.
 6. Behälter nach einem der Ansprüche 1 bis 5, dadurch gekennzeichnet, daß die faltbare Klappe (9, 10, 11) ferner Mittel aufweist, um sie von dem Behälterkörper vollständig zu lösen.
 7. Stanzstück zum Bilden eines Behälters nach einen der Ansprüche 1 bis 7, das mindestens eine Klappe aufweist, die sich von der Seite mindestens einer der Behälterwände (4) erstreckt, wobei die Klappe (9-11) auf entsprechende Behälterwände (3, 5, 4) faltbar ist, nachdem der Behälter gebildet ist, dadurch gekennzeichnet, daß der Endrandbereich der faltbaren Klappe (11) in bezug auf den übrigen Teil der Klappe (11) von einer vorgegebenen Bruchlinie (15) definiert ist, um einen Aufnahmebereich für ein oder mehr Verbindungsstellen zu bilden, um den Endrandbereich (13) mit einer entsprechenden Behälterwand (4) dauerhaft zu verbinden, nachdem der Behälter gebildet ist.
 8. Stanzstück nach Anspruch 7, wobei die Bruchlinie (15) mit einem vorspringenden Bereich versehen ist und ein Schlitz (16) in Übereinstimmung damit an der entsprechenden Behälterwand (4) angeordnet ist.
 9. Verfahren zum Herstellen eines Behälters nach einem der Ansprüche 1 bis 7, das die folgenden Schritte aufweist:
Bereitstellen eines Stanzstücks (1), das entlang mindestens einer seiner Seiten (12) mit mindestens einer faltbaren Klappe (9-11) derart versehen ist, daß diese außen liegt und fähig ist, mindestens einem Teil von ein oder mehr entsprechenden Wänden (3, 5, 4) des gebildeten Behälters überlagert zu werden;
Aufdrucken eines erforderlichen Texts und/oder einer erforderlichen Information vor oder nach der Herstellung des Stanzstücks aus die Wand oder die Wände (9, 10, 11) und/oder auf die Innenseite der faltbaren Klappe(n) (3, 5, 4);
Falten und Verkleben der gestanzten Wände (2, 6) miteinander, um den Behälterkörper zu bilden; und
Falten der Klappe(n) (9-11) und lösbares Befestigen derselben auf der entsprechenden Wand (den entsprechenden Wänden) (3, 5, 4) des Behälters, dadurch gekennzeichnet, daß eine vorgegebene Bruchlinie (15) an dem Endrand (13) der faltbaren Klappe (11) gestanzt wird, um den Endrandbereich (13) gegenüber dem übrigen Bereich der Klappe (11) zum definieren, und daß der Endrand (13) beim Bilden der Behälters mit dem entsprechenden Bereich (14) der entsprechenden Behälterwand (4) dauerhaft verbunden wird.
 10. Verfahren nach Anspruch 9, um einen Behälter nach Anspruch 3 herzustellen, gekennzeichnet durch die folgenden weiteren Schritte:
Zuführen der Stanzstücke (1) zu einer Falt- und Leimmaschine, wobei die faltbare Klappe (9-11) senkrecht zu der Zuführrichtung ist;
Ausführen eines ersten Faltens, indem die beiden zu verbindenden Behälterwände (2, 6) zueinander benachbart getrieben werden;
Aufbringen eines Klebstoffs in Übereinstimmung mit mindestens einer der Wände (2, 6) und dem Endrandbereich (13) der Klappe (9-11);
Ausführen eines zweiten Faltens, indem die Wände (2, 6) miteinander verklebt werden und eine erste Wand (3) des Behälters dem mehr innen liegenden Teil (9) der faltbaren Klappe (9-11) überlagert wird; und

Ausführen eines dritten Faltens, indem zwei aufeinanderfolgende Wände des Behälters (5, 4) den übrigen zwei Rändern (10, 11) der faltbaren Klappe (9-11) überlagert werden und der Endrand (13) der faltbaren Klappe an der entsprechenden Wand (4) der Schachtel, die mit dem Schlitz (16) versehen ist, befestigt wird.

Revendications

1. Récipient, en particulier pour des emballages de médicaments et de produits similaires, du type constitué par une pièce d'un seul tenant (1) découpée à l'emporte-pièce, repliée et collée, et dans lequel au moins l'un des côtés de ladite pièce découpée à l'emporte-pièce comporte au moins un rabat (9, 10, 11) pouvant être replié à l'extérieur du récipient lui-même et comportant des moyens de liaison amovibles (15, 6a) servant à maintenir le ou lesdits rabats repliables (9, 10, 11) de manière qu'ils adhèrent sensiblement à une ou plusieurs parois correspondantes (3, 5, 4) du récipient formé et puissent être dépliés lorsqu'on le désire, et dans lequel une information, des avertissements ou des messages similaires sont imprimés sur au moins une partie du ou desdits rabats (9, 10, 11) et/ou de la ou desdites parois correspondantes (3, 5, 4), caractérisé en ce que lesdits moyens de liaison amovible comprennent un ou plusieurs points de liaison (6a) disposé entre le bord d'extrémité (13) dudit rabat repliable (11) et la paroi sous-jacente du récipient de manière à fixer à demeure ledit bord (13) à ladite paroi (4), ladite zone marginale repliée étant définie par rapport à la partie restante dudit rabat (11) par une ligne de rupture prépositionnée (15), qui permet de détacher ladite partie restante dudit rabat (11) de la paroi correspondante (4) du récipient et du bord d'extrémité (13).
2. Récipient selon la revendication 1, comprenant en outre des moyens (15, 16) pour fixer d'une manière réversible ladite partie restante du rabat (11) à la paroi correspondante (4) du récipient.
3. Récipient selon la revendication 1 ou 2, caractérisé en ce que ledit rabat repliable est formé par trois parties (9, 10, 11) solidaires les unes des autres et solidaires dudit côté de la pièce (1) découpée à l'emporte-pièce, lesdites parties étant superposées à un nombre correspondant de parois (3, 4, 5) du récipient.
4. Récipient selon la revendication 2 ou 3, caractérisé en ce que lesdits moyens de fixation réversibles se présentent sous la forme d'une ou de plusieurs zones pourvues d'un adhésif pouvant être repositionné.
5. Récipient selon la revendication 2 ou 3, caractérisé en ce que lesdits moyens de fixation réversibles se présentent sous la forme d'au moins une fente (16) ménagée dans ladite paroi (4), en correspondance avec ladite ligne de rupture (15) dudit volet repliable (11).
6. Récipient selon l'une des revendications 1 à 5, caractérisé en ce que ledit rebord repliable (9, 10, 11) comporte en outre des moyens pour détacher complètement ce rabat du corps du récipient.
7. Pièce découpée à l'emporte-pièce, destinée à former un récipient selon l'une des revendications 1 à 7, comprenant au moins un rabat s'étendant à partir du côté d'au moins l'une des parois (4) du récipient, ledit rabat (9-11) pouvant être replié sur des parois correspondantes (3, 5, 4) du récipient une fois que le récipient est formé, caractérisé en ce que la zone marginale d'extrémité dudit rabat repliable (11) est définie par rapport à la partie restante dudit rabat (11) au moyen d'une ligne de rupture prépositionnée (15) de manière à former une zone de réception pour un ou plusieurs points de liaison de manière à fixer à demeure ladite zone de bord d'extrémité (13) à une paroi correspondante (4) du récipient une fois que ce dernier est formé.
8. Pièce découpée à l'emporte-pièce selon la revendication 7, dans laquelle ladite ligne de rupture (15) comporte une partie saillante, et une fente (16) est située, de façon correspondante, sur la paroi correspondante (4) du récipient.
9. Procédé pour fabriquer un récipient selon l'une quelconque des revendications 1 à 7, comprenant les étapes consistant à :
 - prendre une pièce (1) découpée à l'emporte-pièce et comportant, le long d'au moins l'un de ses côtés (12), au moins un rabat repliable (9-11), de sorte qu'il est situé à l'extérieur et peut être superposé à au moins une partie d'une ou de plusieurs parois correspondantes (3, 5, 4) du récipient formé;
 - imprimer, avant ou après la fabrication de ladite pièce découpée à l'emporte-pièce, un texte et/ou une information nécessaire sur ladite paroi ou sur lesdites parois (9, 10, 11) et/ou

sur la face intérieure du ou desdits volets repliables (3, 5, 4);

replier et coller les unes sur les autres les parois (2, 6) découpées à l'emporte-pièce de manière à former le corps du récipient; et

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replier le ou lesdits volets (9-11) et le ou les fixer de façon amovible sur la ou les parois correspondantes (3, 5, 4) du récipient, caractérisé en ce qu'une ligne de rupture prépositionnée (15) est découpée à l'emporte-pièce au niveau du bord d'extrémité (13) dudit rebord repliable (11) pour définir ladite zone marginale d'extrémité (13) à partir de la partie restante dudit rabat (11), et en ce que ledit bord d'extrémité (13) est fixé à demeure à la zone correspondante (14) de la paroi correspondante (4) du récipient, lors de la formation de ce dernier.

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10. Procédé selon la revendication 9, pour fabriquer un récipient selon la revendication 3, caractérisé par les étapes supplémentaires suivantes consistant à :

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amener lesdites pièces (1) découpées à l'emporte-pièce à une machine de pliage et de collage, ledit rabat repliage (9-11) étant perpendiculaire à la direction d'amenée;

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exécuter un premier pliage en amenant les deux parois (2, 6) du récipient, qui doivent être collées, dans des positions réciproquement adjacentes;

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appliquer un agent de liaison en correspondance avec au moins l'une desdites parois (2, 6) et la zone de bord d'extrémité (13) dudit rabat (9-11);

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exécuter un second pliage en collant l'une sur l'autre lesdites parois (2, 6) et en superposant une première paroi (30) du récipient à la partie (9), située plus à l'intérieur, dudit rabat repliable (9-11); et

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exécuter un troisième pliage en superposant deux parois suivantes du récipient (5, 4) aux deux bords restants (10, 11) dudit rabat repliable (9-11) et fixer ledit bord d'extrémité (13) du rabat repliable à la paroi correspondante (4) de la boîte, pourvue de ladite fente (16).

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Fig. 1

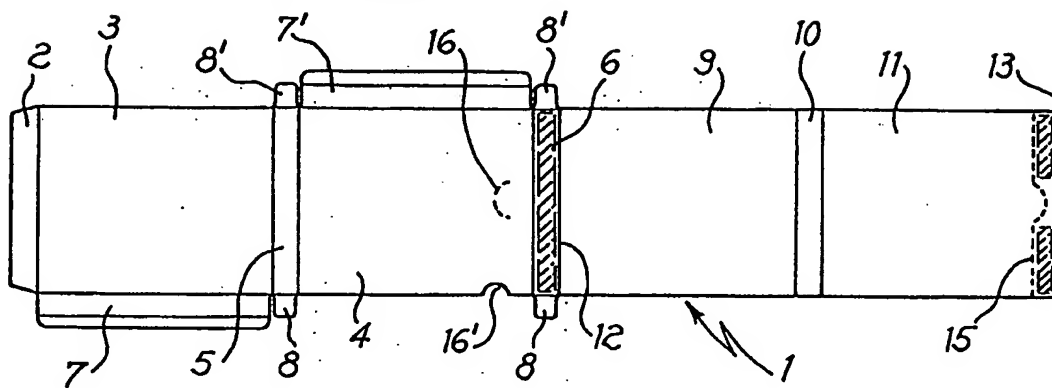


Fig. 2

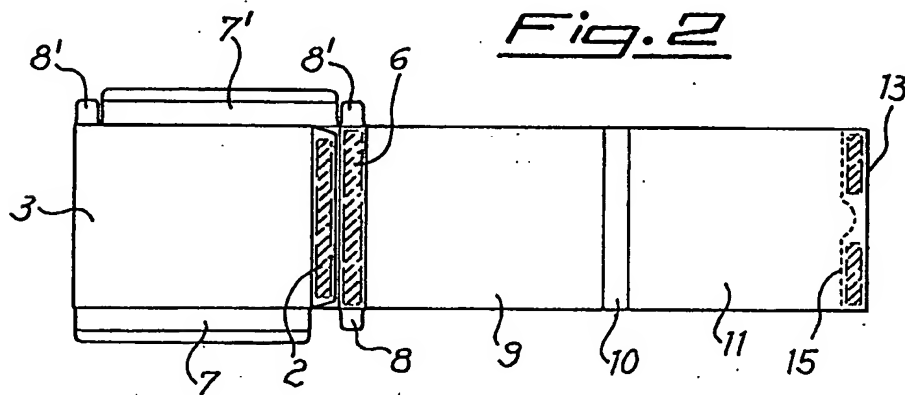


Fig. 3

